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### Automotive SOLDER ALLOYS Selection Chart

Typical Uses	Composition % Weight Tin/Lead	Temperature °F Solidus Pasty Liquidus	Tensile Shear Density #/ in 3
Non-critical sealing and filling, auto body repair and filler.	2/98	601 611 10	3500 3100 .40
Coating steel and copper. Joining parts subject to vibration in cryogenic service.	5/95	586 594 8	4000 2100 .397
Coating steel or copper for durable, corrosion resistance against mild acids, and seawater.	6/94	570 590 20	4800 3000 .390
Coating steel for corrosion resistance where there is subsequent soldering of fittings.	7/93	550 587 37	4200 3000 .389
Fabricating auto radiators & gas tanks, coating and bonding metals subjected to moderate service temperatures. Auto body dent filling.	10/90	514 570 56	4400 3000 .389
	12/88	490 565 75	4500 2600 .380
Coating tubes and sheets, automatic radiator assembly, body filling.	15/85	440 550 110	4600 2700 .380
Coating radiator tubes for joining fins.	20/80	361 531 170	4800 3000 .363
Soldering auto radiators, machine, dip and hand soldering for plumbing fixtures and fittings, superior filler for auto body repairs.	25/75	361 511 150	4900 3500 .369
	30/70	361 491 130	5000 4000 .350
A lower cost alternative alloy than 40/60 for wiping and sweating joints.	35/65	361 477 116	5200 4300 .343
Joining cables, wiping and joining lead pipes, electrical and radiator repairs.	40/60	361 460 99	4900 4400 .328
Soldering radiator cores, roof seams, and decorative joints.	45/55	361 441 80	5700 4900 .321